PRODUCT INFORMATION

TAROBLEND 66 X0

PC/ABS alloy good thermal resistance, flame retardant UL94 V0, improved thermal stability and UV light resistance. Bromine, Chlorine and Antimony compounds free.

ISO short	ISO 1043: PC+ABS FR
Form	Pellets
UL file	E143048

Key Features

- Unfilled
- Good impact - stiffness balance
- Designed for injection moulding applications
- Halogen free
- Flame retardant
- High flow

Availability

- LP: laser printable
- L: UV stabilized
- All colours

Compliance

- UL94 V0 approved all colours at 1,7 mm. UL746 B approved.
- Halogens free according to DIN VDE 0472 part 815

Process

- INJECTION MOULDING

Application

- Power tools
- Household
- Electronic
- Electrical

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,20		
Water Absorption (24h / +23°C)	ISO 62	%	0,3		
Water Absorption at Saturation	ISO 62	%	0,7		
Mould Shrinkage (Parallel)	Internal method	%	0,4 - 0,6		
Mould Shrinkage (Normal)	Internal method	%	0,4 - 0,6		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	50	260°C - 5 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	2750	Speed 1 mm/min	

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design. Values are valid for natural coloured version only.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

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Tensile Yield Strength	ISO 527-1,2	MPa	65	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	40	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2550	Speed 2 mm/min
Flexural Max Strength	ISO 178	MPa	90	Speed 10 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	500	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	38	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	N.B.	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	120	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	114	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	90	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	75	
Continuous service temperature	UL746 B	°C	60	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	7x10E(-5)	-30°C /+30°C

FLAMMABILITY

Flame Behaviour (1,7 mm)	UL94	Class	V0	UL approved
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	960	
Oxigen index	ASTM D2863	%	32	

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	90 - 110°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	< 0,1 %
Suggested Max Regrind	< 15 %
Melt Temperature	240 - 270°C
Feed Temperature	220°C
Rear Temperature	240°C
Middle Temperature	250°C
Front Temperature	255°C
Nozzle Temperature	260°C

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Mould Temperature	50 - 90°C
Injection Rate	Medium to Fast
Injection Pressure	10 - 35 Mpa
Packing Pressure	12 - 40 Mpa
Back Pressure	< 4 Mpa
Screw Revolving Speed	50 - 100 rpm
Cushion	> 4 mm
Screw L/D Ratio	16 - 20
Vent Depth	0,02 mm

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.